

# Work Order ID 83191

April-13-12 1:01:26 PM

**\*83191\***

Page 1

Item ID: D412-698-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Cabin Door Roller, LH

Stop **\*NS2\***

Start Date: 13/04/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/13* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN D412-698	Rev E								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-698-011 CHG003								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*DAS 16*

*12/08/23*

*2x*

*12-8-22*

*DAS 16*

*12/08/23*

*72*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83191

**\*83191\***

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Item ID: D412-698-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Cabin Door Roller, LH

Stop

**\*NS2\***

Start Date: 13/04/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

**\*130\***

Packaging

Packaging

0.00

*SHR*

*(50)*

*12/1/23*

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-011

Location: \_\_\_\_\_

140

**\*140\***

QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*MCJ 12108/23*

*ME 12-08-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 83191

\*83191\*

Parent Item: D412-698-011

\*D412-698-011\*

Parent Item Name: Cabin Door Roller, LH

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from  
Step 1,3KJ/DS  
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S <sub>B</sub> D3121-141 *D3121-141* Bracket Assembly		Manufactured	No			100	Each	12.0000	** 6	B 85488			

Location	Loc Qty	Loc Code
ST235	12	
80097	12	

S <sub>2</sub> D3121-143 *D3121-143* Bracket Assembly		Manufactured	No			110	Each	8.0000	** 2	B 84413			
--	--	--------------	----	--	--	-----	------	--------	---------	---------	--	--	--

Location	Loc Qty	Loc Code
ST235A	8	
75031	4	
80098	4	

S <sub>2</sub> D3183-043 *D3183-043* Bracket Assembly		Manufactured	No			110	Each	3.0000	** 2	B 82688			
--	--	--------------	----	--	--	-----	------	--------	---------	---------	--	--	--

Location	Loc Qty	Loc Code
ST235	3	
75033	3	

S <sub>2</sub> D3137-043 *D3137-043* Bracket Assembly		Manufactured	No			110	Each	6.0000	** 2	B 80029			
--	--	--------------	----	--	--	-----	------	--------	---------	---------	--	--	--

Location	Loc Qty	Loc Code
ST235B	6	
79734	6	

B 89427  
12-8-22  
B 83467

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 83191

\*83191\*

Parent Item: D412-698-011

\*D412-698-011\*

Parent Item Name: Cabin Door Roller, LH

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

12.0000

\*D3199-1\*

Bracket

\*\*

9 18

B85467 SP

Location

Loc Qty

Loc Code

ST236

17

78618

4

79797

8

ST236A

-5

Manufactured No

110

Each

8.0000

D3202-1

\*D3202-1\*

Cover

\*\*

1 2

B83506 SP  
12-8-22

Location

Loc Qty

Loc Code

ST241A

8

70294

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Date: 08.05.01

